Work Order ID 125754

Wednesday, October 22, 2014 12:34:13 PM

125754

Item ID: D4354-041 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Bearpaw Wearplate Assembly

Start Date: 10/21/14 **Start Qty:** 1.00 *1*

Required Date: 10/21/14 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** ML5 **Date:** 14-10-22 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**: D4354 / b									
100		0.00							DAS 23 9-89
100						(2)		Dec 14/11/02	
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg (D4354-1)								
304 .063"	Dwg Rev: b								
	Prog Rev: b								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 23 9-89
110						(2)		Dec 14/11/02	
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework	☐
Scrap	☐
Use-as-is	☐
Suspected Unapproved	☐

AGAINST DEPARTMENT/PROCESS

Skid-tube	☐	Crosstube	☐	Water Jet	☐	Engineering	☐
Machining	☐	Small Fab	☐	Prod. Eng. Coor.	☐	Quality	☐
Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
Large Fab	☐	Composite	☐	Supplier	☐		☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐	Bending
☐	Centre Not Concentric
☐	Cracks
☐	Crimp/Kink/Ripple/Wave
☐	Cuffs
☐	Crushing
☐	Heat Treat
☐	Inspection Strip in Tube
☐	Marks/Chatter
☐	Turning Sequence
☐	Wave/Twist in Tube

General

☐	Bend
☐	BOM/Route
☐	Broken/Damage/Defect
☐	Burrs
☐	Contamination
☐	Countersink
☐	Cut Too Short
☐	Drawing
☐	Drill Holes
☐	Finish
☐	Fit/Function
☐	Folio/Program
☐	Grain
☐	Hardware
☐	Inspection Incomplete/Unqualified
☐	Instructions Incomplete/Unclear
☐	Misaligned/off center
☐	Mislabeled
☐	Misread
☐	Off-set
☐	Out of Calibration
☐	Out of Sequence
☐	Outside Dimensions
☐	Over/Under tolerance
☐	Part Incorrect
☐	Part Lost/Missing
☐	Part Moved
☐	Positioned Wrong
☐	Power Loss/Surge
☐	Pressure/Forced
☐	Set-up
☐	Temperature/Cure
☐	Weld
☐	Wrong Stock Pulled
☐	Other

Work Order ID 125754

Wednesday, October 22, 2014 12:34:13 PM

125754

Item ID: D4354-041 **Accept** *N9000040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Bearpaw Wearplate Assembly

Start Date: 10/21/14 **Start Qty:** 1.00 *1*

Required Date: 10/21/14 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00				2			DAS 38 9-89
120									
QC	**Memo**	0.00							
Quality Control									NOV 04 2014
130		0.00				2			14-11-11
130									
Large Fab	**Memo**	0.00							
Large Fab	1- Weld cups as per dwg A/R S.S. ROD BATCH: M123823								
	2- Apply hardfacing on wearplate as indicated on dwg A/R HARDCOAT 2059B BATCH: 130145								
140	QC5- Inspect part completeness to step on W/O	0.00				2			DAS 38 9-89
140									
QC	**Memo**	0.00							
Quality Control									NOV 12 2014

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework	☐
Scrap	☐
Use-as-is	☐
Suspected Unapproved	☐

AGAINST DEPARTMENT/PROCESS

Skid-tube	☐	Crosstube	☐	Water Jet	☐	Engineering	☐
Machining	☐	Small Fab	☐	Prod. Eng. Coor.	☐	Quality	☐
Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
Large Fab	☐	Composite	☐	Supplier	☐		☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐	Bending
☐	Centre Not Concentric
☐	Cracks
☐	Crimp/Kink/Ripple/Wave
☐	Cuffs
☐	Crushing
☐	Heat Treat
☐	Inspection Strip in Tube
☐	Marks/Chatter
☐	Turning Sequence
☐	Wave/Twist in Tube

General

☐	Bend
☐	BOM/Route
☐	Broken/Damage/Defect
☐	Burrs
☐	Contamination
☐	Countersink
☐	Cut Too Short
☐	Drawing
☐	Drill Holes
☐	Finish
☐	Fit/Function
☐	Folio/Program
☐	Grain
☐	Hardware
☐	Inspection Incomplete/Unqualified
☐	Instructions Incomplete/Unclear
☐	Misaligned/off center
☐	Mislabeled
☐	Misread
☐	Off-set
☐	Out of Calibration
☐	Out of Sequence
☐	Outside Dimensions
☐	Over/Under tolerance
☐	Part Incorrect
☐	Part Lost/Missing
☐	Part Moved
☐	Positioned Wrong
☐	Power Loss/Surge
☐	Pressure/Forced
☐	Set-up
☐	Temperature/Cure
☐	Weld
☐	Wrong Stock Pulled
☐	Other

Item ID: D4354-041 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Bearpaw Wearplate Assembly
Start Date: 10/21/14 **Start Qty:** 1.00 *1* **Cust Item ID:**
Required Date: 10/21/14 **Req'd Qty:** 1.00 *1* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC9- Inspect visual per QSI004- Fusion Welds	0.00							DAS 50 9-89
150						2	14-11-12		
QC	**Memo**	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: ST6006	0.00							DAS 86 9-89
160						2	NOV 13 2014		
Packaging	**Memo**	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170							14/11/17		
QC	**Memo**	0.00							
Quality Control									

MF 14-11-14

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework	☐
Scrap	☐
Use-as-is	☐
Suspected Unapproved	☐

AGAINST DEPARTMENT/PROCESS

Skid-tube	☐	Crosstube	☐	Water Jet	☐	Engineering	☐
Machining	☐	Small Fab	☐	Prod. Eng. Coor.	☐	Quality	☐
Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
Large Fab	☐	Composite	☐	Supplier	☐		☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Picklist Print

Wednesday, October 22, 2014 12:34:13 PM

Work Order ID: 125754 *125754*

Parent Item: D4354-041 *D4354-041*

Parent Item Name: Bearpaw Wearplate Assembly

Start Date: 10/21/14 **Required Date:** 10/21/14

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP REV:A 11.04.11 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4379-1		Manufactured	No			130	Each	47.0000	10	10			
D4379-1									**				
Wearplate Cup													

Location	Loc Qty	Loc Code	
WA002	47		
117086	5		
123053	42		20

M304S16GA		Purchased	No			100	sf	423.0485	0.9223	1			
M304S16GA									**				
304/316 Sheet .063													

Location	Loc Qty	Loc Code	
MAT020	294.0485		
M127821	71.317		
M129449	222.7315		3.999
TPI	129		
M129545	129		

14-11-11 DAS

14/11/03 DAS 23 9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
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☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
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☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
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☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

DART AEROSPACE LTD	Work Order:	125754
Description: Bearpaw Wearplate	Part Number:	D4354-1
Inspection Dwg: D4354 Rev: B		Page 1 of 1

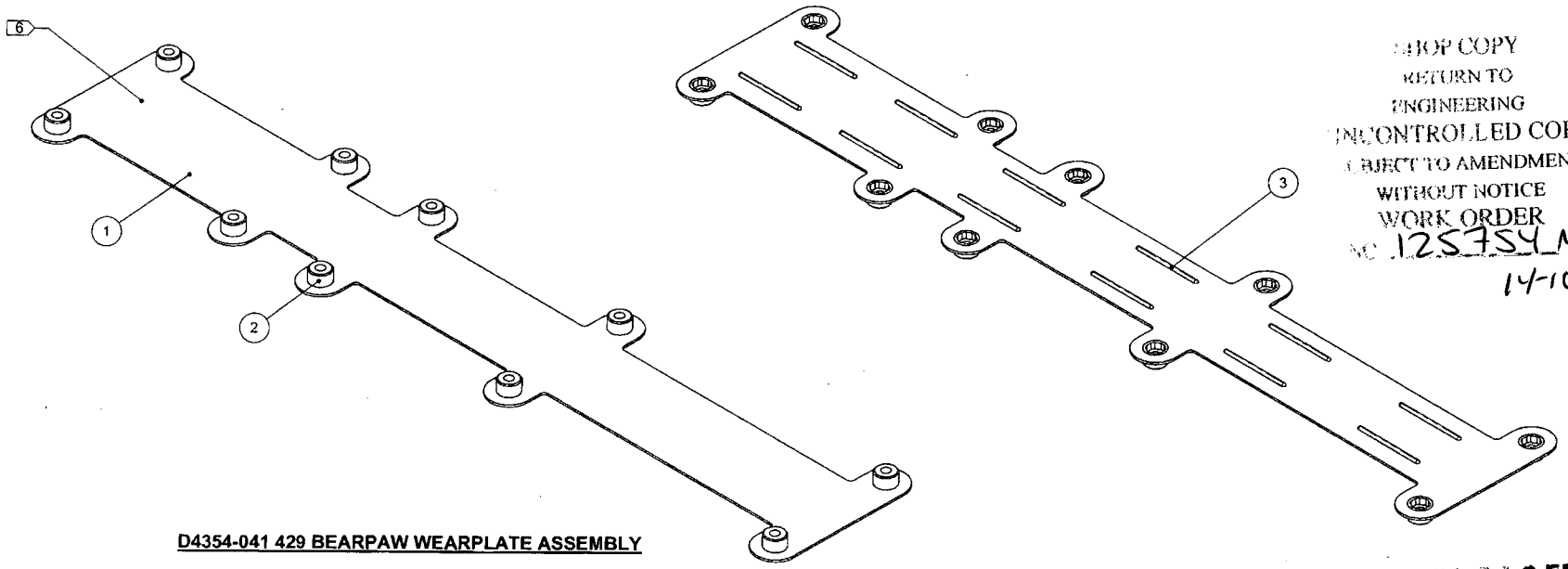
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	.626	✓		V-JKM-01	
1.25	+/-0.030	1.25	✓		V-JKM-04	
1.31	+/-0.030	1.31	✓		T-JKM-06	
3.813	+/-0.010	3.810	✓			
5.06	+/-0.030	5.057	✓			
1.65	+/-0.030	1.65	✓			
0.63	+/-0.030	.63	✓			
6.150	+/-0.010	6.156	✓			
3.038	+/-0.010	3.034	✓			
6.563	+/-0.010	6.565	✓			
9.250	+/-0.010	9.252	✓			
26.25	+/-0.030	26.25	✓			
0.063	+/-0.010	.059	✓			
	DAS 23 9-89					

Measured by:	DAS 23 9-89	Audited by:	DAS 38 9-89	Preliminary Approval:	
Date:	14/11/02	Date:	NOV 04 2014	Date:	

Rev	Date	Change		Revised by	Approved
A	11.07.26	New Issue	P/O D4354-041	KJ	

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4354-041	429 BEARPAW WEARPLATE ASSEMBLY
1	1	D4354-1	429 BEARPAW WEARPLATE
2	10	D4379-1	WEARPLATE CUP
3	A/R	2059B	HARDCOAT



D4354-041 429 BEARPAW WEARPLATE ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 125754_MLS
14-10-22

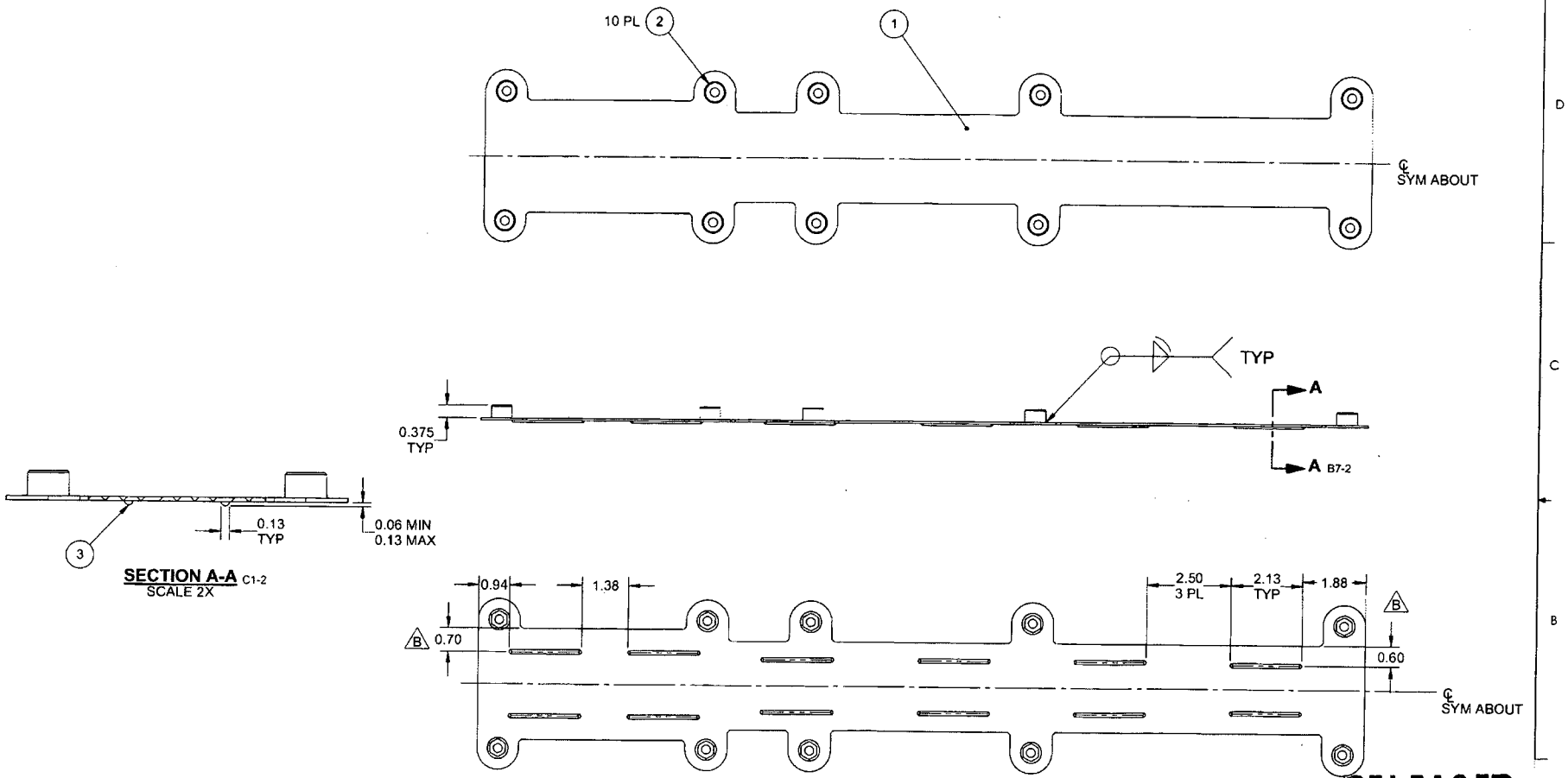
RELEASED
2011 -05- 26

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4354-041" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
7) WEIGHT: 1.76 lbs
8) WELDING: PER QSI 004
9) 2059B HARDCOAT WELD, 12 PL

REV.	DESCRIPTION	BY	DATE
B	SHT 3, LIGHTENING HOLES DELETED. SHT 2 ZONE B1 & B6 HARDCOAT RELOCATED. REASON: PROTECTION OF BEARPAW.	AJS	11.05.16
A	NEW ISSUE	AJS	11.03.24

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4354	REV. B
MFG. APPR.			SHEET 1 OF 3
APPROVED		TITLE 429 BEARPAW WEARPLATE ASSEMBLY	SCALE NTS
DE APPR.			
DATE	11.05.16		

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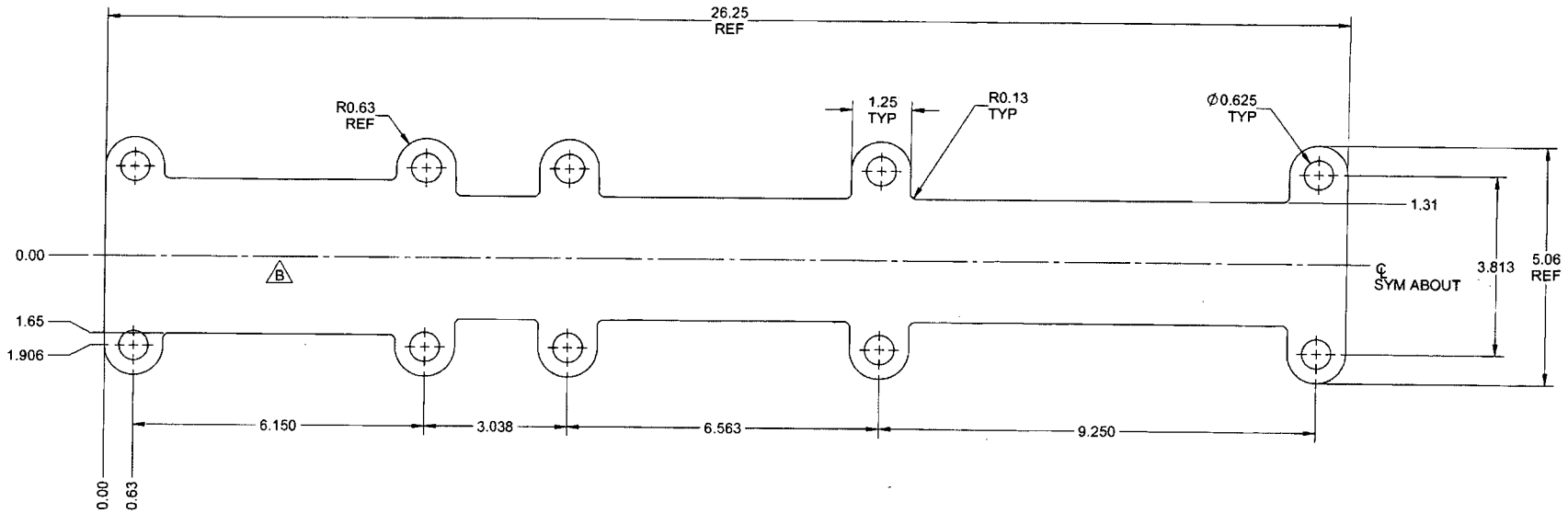


SECTION A-A C1-2
SCALE 2X

D4354-041 429 BEARPAW WEARPLATE ASSEMBLY

RELEASED
2011 -05- 26

DESIGN	AJS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D4354	REV. B
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE 429 BEARPAW WEARPLATE ASSEMBLY	SCALE NTS
DE APPR.			
DATE 11.05.16		COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



D4354-1 429 BEARPAW WEARPLATE

RELEASED
2011 -05- 26
WD

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH , 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S16GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 1.52 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. D4354 REV. B
MFG. APPR.		SHEET 3 OF 3
APPROVED		TITLE 429 BEARPAW WEARPLATE ASSEMBLY SCALE NTS
DE APPR.		
DATE	11.05.16	

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